

November-03-11 8:58:29 AM

Page 1

**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**\*8\***

**Cust Item ID:**

**\*8\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Date:

Date:

Stop \*NR2\*

100		0.00	
*1000*			
Waterjet			
FLOW CNC Waterjet			
304, 063			
	Memo	0.00	
	Cut as per dwg D3589		
	Prog Rev: <u>5</u>		
	Dwg Rev: <u>B</u>		
	Deburr as required		
110	QC2- Inspect parts off machine FAI/FAIB	0.00	
*110*			
QC			
Quality Control	Memo	0.00	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

November-03-11 8:58:29 AM

Page 2

Setup Start \*NS1\*

Stop \*NS2\*

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

0.00

Schulz

## Quality Control

0.00

0.00

-SB 11/4/10

### Small Fab

1- Form as per dwg

0.00

0.00

Sulawo

### Quality Control

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**\*76030\***

November-03-11 8:58:29 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 03/11/2011      **Start Qty:** 8.00

**\*8\***

**Cust Item ID:**

**Required Date: 17/11/2011      Req'd Qty: 8.00**

**\*8\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

Identify as per dwg & Stock Location. STL 0A 0.00

**\*150\***

### Packaging

## Memo

0.00

### Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

OC

## Memo

0.00

## Quality Control

ulu/lu/lu

11-11-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-03-11 8:58:33 AM

Page 1

Work Order ID: 76030

**\*76030\***

Parent Item: D3589-7

**\*D3589-7\***

Parent Item Name: AFT GUIDE PLATE

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-06-05 new issue DD verified by:ec IPP Rev:B 09-02-20 rev.b asper dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

164.9000

0.06

0.505263

1,

**\*M304S16GA\***

**\*\***

11-11-7

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

164.9

119346

164.9

119346

12

W/O:		WORK ORDER CHANGES					
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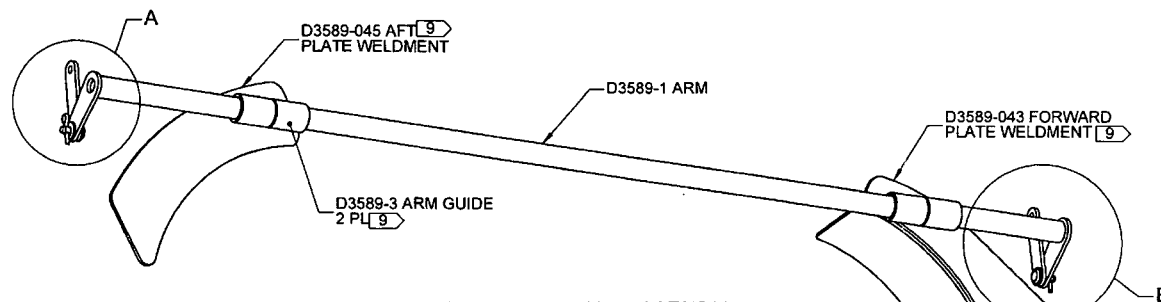
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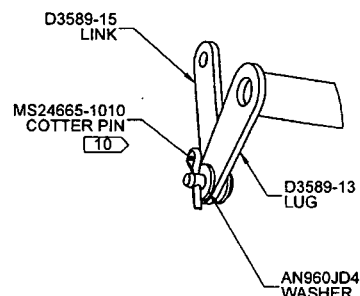




QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN

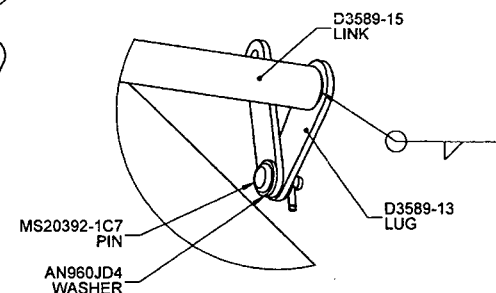


**D3589-041 LATCH ASSEMBLY**



**DETAIL A: LINK ASSEMBLY DETAIL**

SCALE 2X  
2 PL



**DETAIL B: WELDING AND  
LINK ASSEMBLY DETAIL**

SCALE 2X  
2 PL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76030 M.C. J  
11/11/03

**D3589-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

**RELEASED**  
09/02/03

B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-8 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.25		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D3589**  
REV. B  
SHEET 1 OF 8  
TITLE  
**LATCH ASSEMBLY**  
SCALE  
NTS

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

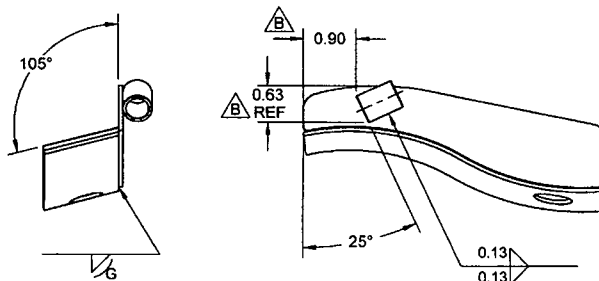
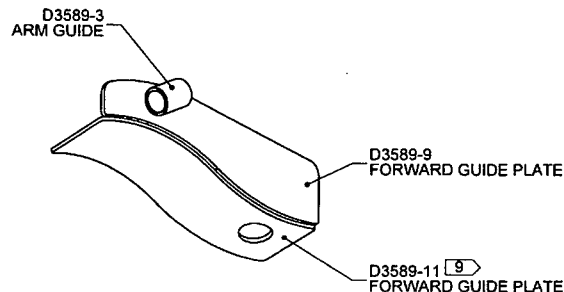
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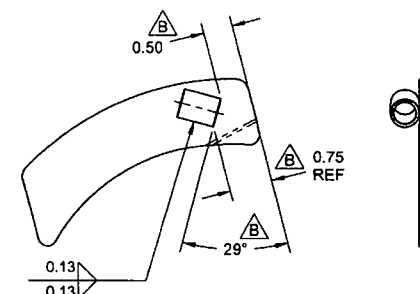
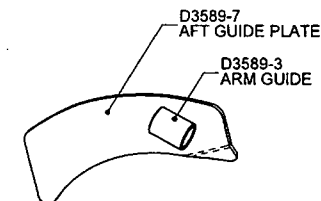
**NOTE:** Date & initial all entries

76030

QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



**D3589-043 FORWARD PLATE WELDMENT**



**D3589-045 AFT PLATE WELDMENT**

**D3589-043/-045 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
  - D3589-043 = 0.22 lbs
  - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

**RELEASED**  
09/03/05

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3589</b>	REV. B
MFG. APPR.			SHEET 2 OF 8
APPROVED		TITLE <b>LATCH ASSEMBLY</b>	SCALE
DE APPR.			NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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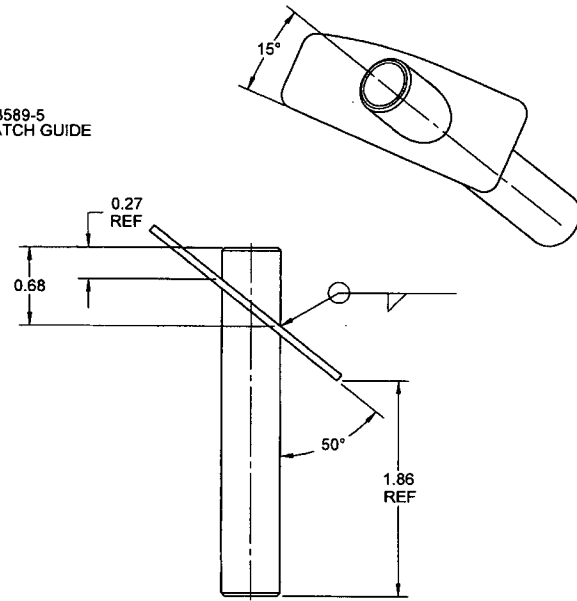
**NOTE:** Date & initial all entries

76030

QTY -047	QTY -049	P/N	DESCRIPTION
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE

D3589-17  
FORWARD GUIDE PLATE

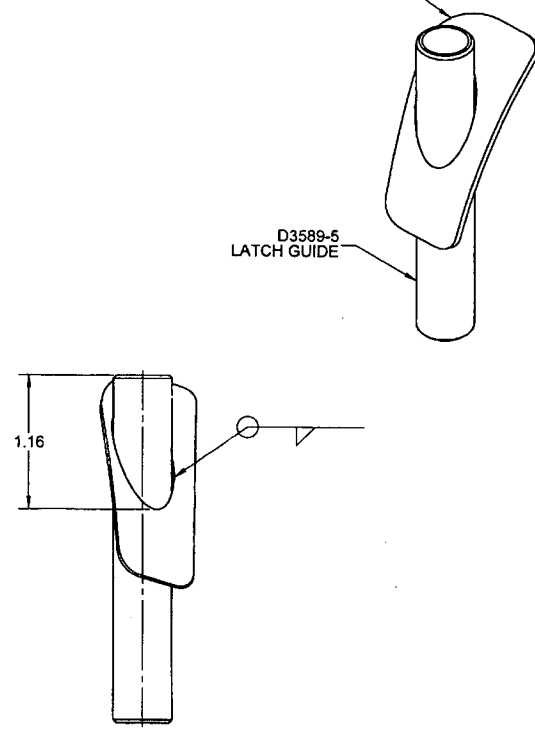
D3589-5  
LATCH GUIDE



**D3589-047 FORWARD GUIDE**

D3589-19  
AFT GUIDE PLATE

D3589-5  
LATCH GUIDE



**D3589-049 AFT GUIDE**

**D3589-047/-049 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

**RELEASED**  
*9/10/08 MJB*

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3589</b> TITLE <b>LATCH ASSEMBLY</b> DATE <b>08.06.25</b>	REV. B
DRAWN			SHEET 3 OF 8
CHECKED			SCALE
MFG. APPR.			NTS
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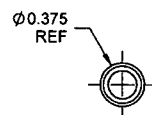
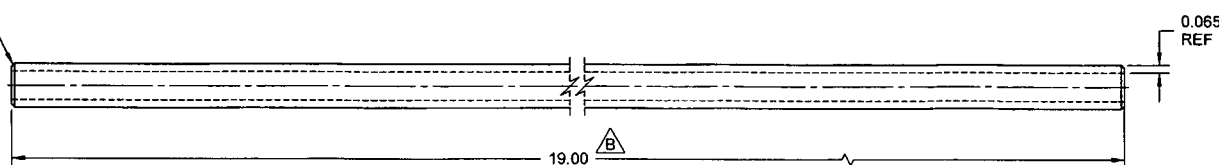
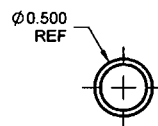
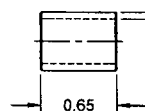
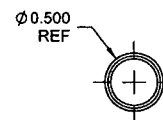
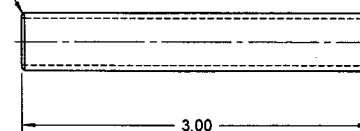
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**NOTE:** Date & initial all entries







76030

0.03 X 45°  
CHAMFER  
2 PL0.065  
REF**D3589-1 ARM**0.058  
REF**D3589-3 ARM GUIDE**0.03 X 45°  
CHAMFER  
2 PL0.049  
REF**D3589-5 LATCH GUIDE****D3589-1/-3/-5 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)  
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)  
 D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)

- 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: - D3589-1 = 0.34 lbs  
 - D3589-3 = 0.01 lbs  
 - D3589-5 = 0.06 lbs

RELEASED  
9/12/05

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D3589	SHEET 4 OF 8
APPROVED			TITLE	SCALE
DE APPR.			LATCH ASSEMBLY	NTS
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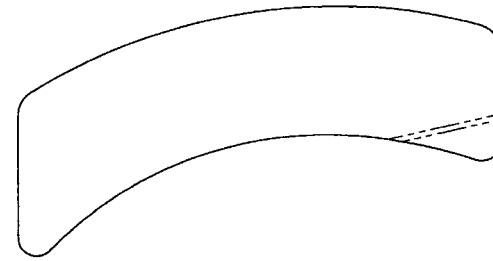
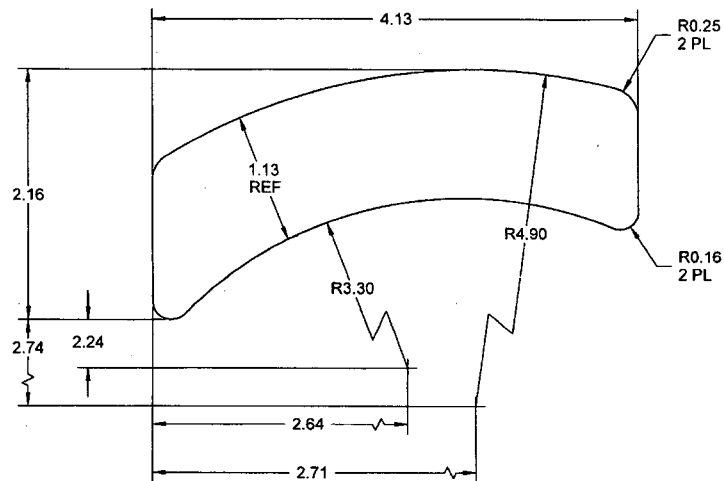
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**NOTE:** Date & initial all entries

76030



**D3589-7 AFT GUIDE PLATE**  
MAKE FROM D3589-7F

**D3589-7F AFT GUIDE PLATE**  
**FLAT PATTERN**

**RELEASED**  
09/02/05 NTP

**D3589-7/-7F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D3589	SHEET 5 OF 8
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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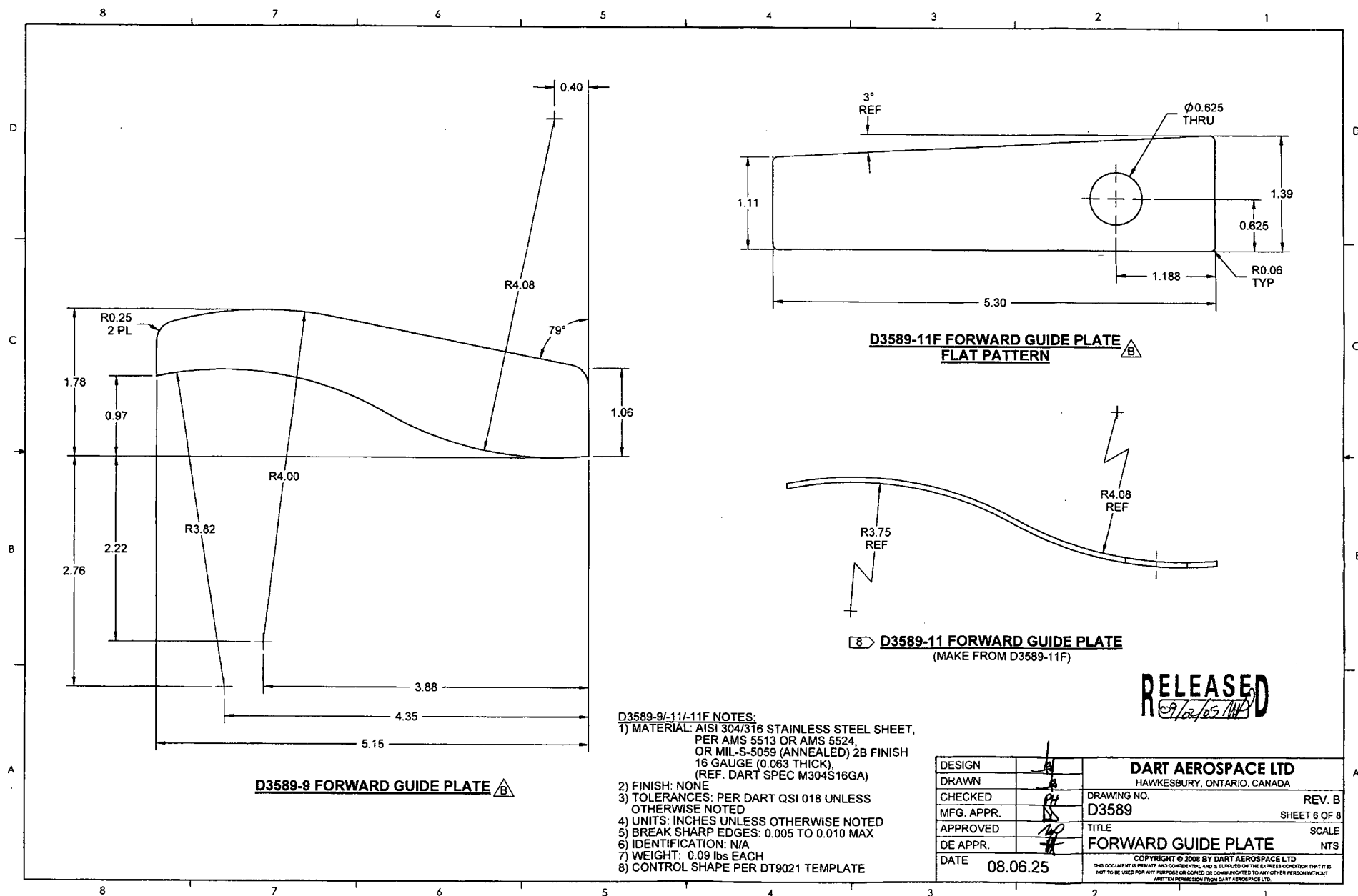
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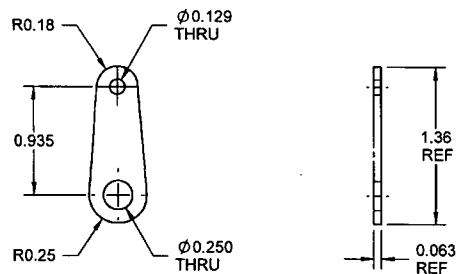
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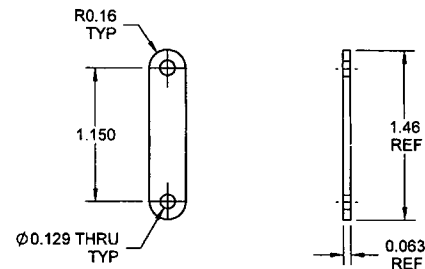
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

76030



**D3589-13 LUG**



**D3589-15 LINK**

**RELEASED**  
09/02/05

**D3589-13/-15 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

DESIGN	<del>1</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>1</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>1</del>	<b>D3589</b>	SHEET 7 OF 8
APPROVED	<del>1</del>	TITLE	SCALE
DE APPR.	<del>1</del>	<b>LATCH ASSEMBLY</b>	NTS
DATE	08.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

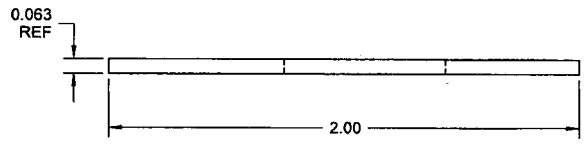
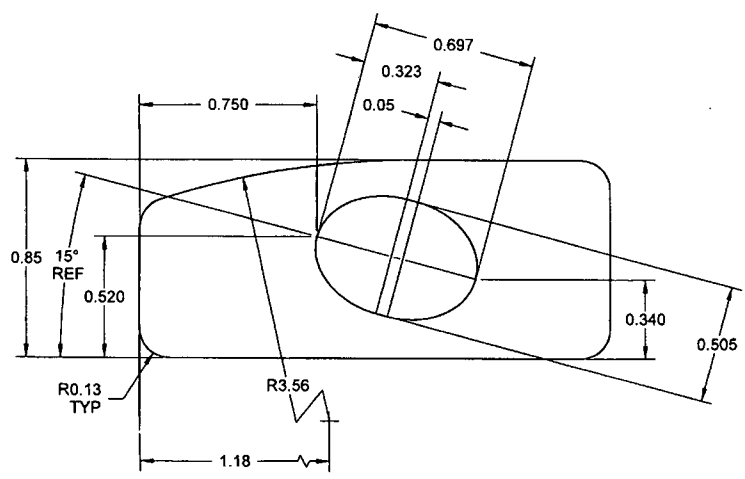
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

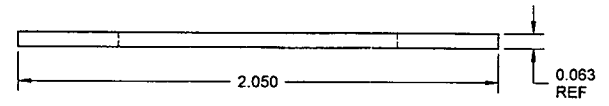
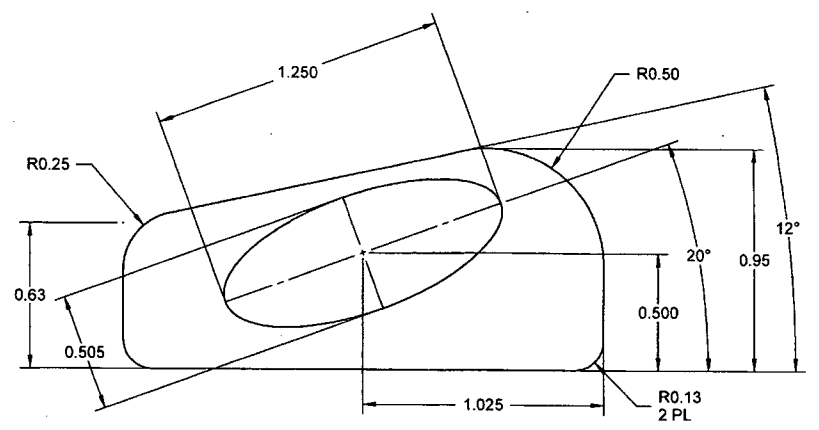
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

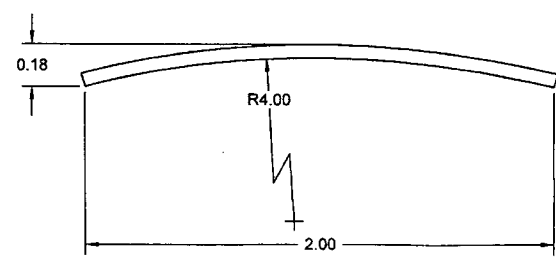
76030



**D3589-17 FORWARD GUIDE PLATE**



**D3589-19F AFT GUIDE PLATE FLAT PATTERN**



**D3589-19 AFT GUIDE PLATE**  
(MAKE FROM D3589-19F)

**RELEASED**  
09/02/05

**D3589-17/-19/-19F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.06.25

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3589</b>	REV. B
TITLE <b>LATCH ASSEMBLY</b>	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries